



Dart Aerospace Ltd.
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D3121-25
Job Sheet 182280



Part No: D3121-25

Job Qty: 150 ea

Part Name: Delrin Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 06-05-10 JLM IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	150 Ea		9/7/18	0.00	0.00	Start Up Machining-1		JBD 15/10/12
100	Hardinge	150 pcs		9/7/18	0.02	2.31	Hardinge		
120	QC	150 pcs		9/7/18	0.00	0.00	QC8		28 15/10/12
130	Packaging	150 pcs		9/7/18	0.00	0.00	Packaging3-1	OCT 02 2018	
140	QC21-SA	150 Ea		9/7/18	0.00	0.00	QC21		9-5

Part Op Descriptions: 100 - 1-Turn D3121-25 Cap as per Folio FA387

OCT 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRLNR1.000	Delrin Round Bar 1" Color: Black	4.8000 ft (.032 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELRLNR1.000	5	14	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.315inches ± 0.010	0.325 0.305		
2	Cap	1.000inches ± 0.010	1.010 0.990		
3	Cap	0.838inches ± 0.002	0.840 0.836		
4	Cap	0.063inches ± 0.010	0.073 0.053		
5	Cap	0.010inches ± 0.010	0.020 0.000		
6	Cap	0.230inches ± 0.001	0.231 0.229		
7	Cap	0.865inches ± 0.001	0.866 0.864		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Desc: _____	DISPOSITION Rework ☐ Scrap ☐ Use as is ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐			
		DART AEROSPACE Part: D3121-25 Job No: 182280 Serial No/Batch: S115198 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/02/18		DART AEROSPACE Container No: S115198 DART Aerospace Ltd. 1270 Ardair Street Hamilton, ON K8A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause			
Environment	☐	No 1	
Design	☐	Open	
Doc/Data	☐	Offset/Setup	Centre Not Concentric
Equip/Tooling	☐	Supplier	Cracks
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave
Material	☐	Use for Testing	Cuffs
Internal Transport	☐	Poor Information	Crushing
Tribal Knowledge	☐	Rushing	Heat Treat
LOA	☐	Product Improvement	Wave/Twist in Tube
Substation	☐	Process Improvement	Marks/Chatter
Past Expiry Date	☐	Manufacturing Process	
Misidentified	☐	Past Due	
OTHER : _____			

r Loss/Surge Program	☐	Positioned Wrong	
	☐	Outside Dimensions	
	☐	Over/Under tolerance	
	☐	Part Incorrect	
	☐	Part Lost/Missing	
	☐	Part Moved	
	☐	Drawing	
	☐	Finish	
	☐	Misread	
	☐	Turning Sequence	